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007934

D412-698-012
Job Sheet 186028



Part No: D412-698-012

Job Qty: 1 pcs

Part Name: Cabin Door Roller RH Aluminum Door



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 11/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3
KJ/DS IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	11/22/18		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

					Packaging 1 - 31				
					Packaging 1 - 32				
					Packaging 1 - 33				
					Packaging 1 - 34				
					Packaging 1 - 35				
					Packaging 1 - 36				
					120 QC 4	1 pcs	11/22/18	0.00 0.00	QC 4 - 26
QC 4 - 28									
QC 4 - 38									
QC 4 - 42									
QC 4 - 58									
QC 4 - 6	DAS								
QC 4 - 69	69								
QC 4 - 9	9-89								
				QC 4 - 46	DAS				
				130 Packaging 3-1 - Stock - B4B	1 pcs	11/22/18	0.00 0.00	Packaging 3 - 1 - B4B	69
								Packaging 3 - 2 - B4B	9-89
								Packaging 3 - 3 - B4B	
								Packaging 3 - 4 - B4B	
								Packaging 3 - 5 - B4B	
								Packaging 3 - 6 - B4B	
								Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B									
Packaging 3 - 9 - B4B									
Packaging 3 - 10 - B4B									
Packaging 3 - 11 - B4B									
Packaging 3 - 12 - B4B									
Packaging 3 - 13 - B4B									
Packaging 3 - 14 - B4B									
Packaging 3 - 15 - B4B									
Packaging 3 - 16 - B4B									
Packaging 3 - 17 - B4B									
Packaging 3 - 18 - B4B									
Packaging 3 - 19 - B4B									
Packaging 3 - 20 - B4B									
Packaging 3 - 21 - B4B									
Packaging 3 - 22 - B4B									
Packaging 3 - 23 - B4B									
Packaging 3 - 24 - B4B									
Packaging 3 - 25 - B4B									
Packaging 3 - 26 - B4B									
Packaging 3 - 27 - B4B									
Packaging 3 - 28 - B4B									
Packaging 3 - 29 - B4B									
Packaging 3 - 30 - B4B									
Packaging 3 - 31 - B4B									
Packaging 3 - 32 - B4B									
Packaging 3 - 33 - B4B									
Packaging 3 - 34 - B4B									
Packaging 3 - 35 - B4B	DAS								
Packaging 3 - 36 - B4B	21								
135 DC - 1 - B4B	1 pcs	11/22/18	0.00 0.00	DC - 1 - B4B	9-89				
				DC - 2 - B4B					
140 QC 21 - FG	1 pcs	11/22/18	0.00 0.00	QC 21 - FG - 21					
				QC 21 - FG - 70	DAS				
Part Op 110 - (Pick Kit)					21				
Descriptions: 120 - (QC4- 100% Inspect kits for completeness)					9-89				
130 - Identify and pack for shipping as per PPP D412-698-012 Location : FG034									
135 - (Document Control) Photocopy bluefile and create labels per PPP D412-698-012 CHG003									
140 - (QC21- Final Inspection - Work Order Release)									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3121-141 15	Bracket Assembly	3 pcs (3 ea)	110-Packaging 1 - Pick Kit	5135687
D3121-144 15	Bracket Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5104650
D3137-043 19	Bracket Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5117179
D3183-044 20	Bracket Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5133709
D3199-1 22	Bracket	9 pcs (9 ea)	110-Packaging 1 - Pick Kit	50590653 5118093x6
D3202-1 15A	Cover	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5070894

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D3121-141	3	13	0
	D3121-144	1	4	0
	D3137-043	1	3	0
	D3183-044	1	4	0
	D3199-1	9	64	0
	D3202-1	1	13	0

Part Specifications

Specifications could not be found.

Plex 1/30/19 9:08 AM Dart.Hadley.Shannon



Container No: S151080



Part: D412-698-012

Job No: 186028

Serial No/Batch: S151080

Revision: G

Inspector:

Exp Date:

Instructions: TC STC SH92-43 Issue 5 FAA STC SR014461

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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/22/18	0.00	0.00	Start Up Stores/Pkg-2		
110	Packaging	1 pcs		11/22/18	0.00	0.00	Packaging1-4		
120	QC	1 pcs		11/22/18	0.00	0.00	QC4		
130	Packaging	1 pcs		11/22/18	0.00	0.00	Packaging3-2		
135	DC	1 pcs		11/22/18	0.00	0.00	DC		
140	QC21-FG	1 Ea		11/22/18	0.00	0.00	QC21		

Part Op 130 - Identify and pack for shipping as per PPP D412-698-012 Location : FG034
Descriptions: 135 - Photocopy bluefile and create labels per PPP D412-698-012 CHG003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3121-141	Bracket Assembly	3 Ea (3 ea)	90-Start up Operation	
D3121-144	Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	
D3137-043	Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	
D3183-044	Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	
D3199-1	Bracket	9 Ea (9 ea)	90-Start up Operation	
D3202-1	Cover	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3121-141	3	4	0
	D3121-144	1	5	0
	D3137-043	1	4	0
	D3183-044	1	0	0
	D3199-1	9	74	0
	D3202-1	1	14	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

6.0 PARTS LIST – CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW

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Revision: **G**

Date: 17.11.23